

Work Order ID 86188

June-22-12 1:54:42 PM

86188

Page 1

Item ID: D3789-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Clamp

Stop ***NS2***

Start Date: 22/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/22 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3789	Rev A

100 0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut extrusion to 1.250"

Cut @ meter

110 0.00

110

HAAS 1 *Punch*

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA834

Dwg Rev: _____

Folio Rev: _____

Deburr

P/O: 17295

issue P/O to meter

machine as per day D 3789 REV. A

CL 12/06/20

CL 12/06/2020

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

115 *rec'd*

115

QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*rec'd + inspect for transit damage
attached c/c to W/O*

6/22/12 (20)

120
120

QC
Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/12/14

/ 20 PD 12-07-11

130
130

HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

20 NG 12-7-11

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Process Plan:

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

20 ϕ PL 127-11

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

*****Mask bearing bore prior to powder coat*****

START TIME: 8:00

OVENTEMPERATURE: 3200 F

FINISH TIME: 8:30

20x ϕ m/L 12/07/12

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

20x d M 12/07/12

W121841

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Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170	Small Fab					20			FD 12-08-02
Small Fab	Memo	0.00							
Small Fab	1- press fit D2611 bearing after powder coat 2- stake D2611 bearing 4 places each side as per dwg D3789								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: <u>55</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									

SMB 12-8-02 / 1 D45 16 12/06/06

20

12/8/7 (20)

W/O:		WORK ORDER CHANGES					
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			7/10 27 200					

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Stop ***NR2***

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200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/8/12
MLJ12108107

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June-22-12 1:54:50 PM

Page 1

Parent Item: D3789-3

Parent Item Name: Clamp

86188

D3789-3

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: A New Issue 08-12-10 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611		Manufactured	No			100	Each	89.0000	1	20			
D2611 Bearing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST012	86264	89				20			
				79867		29							
				84057		40							
				84434		20							
D2423		Manufactured	No			170	f	462.0150	0.07	1.473684			
D2423 Lug Extrusion													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT006		462.015							
				43722		161.5							
				68331		43.8506							
				81557		256.6644				1.48			

D 3789-3P

X 20

12/2/80 (20)

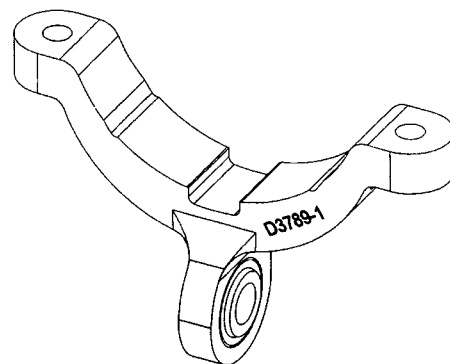
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

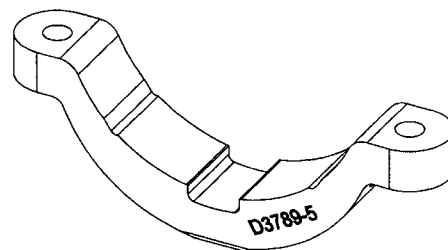
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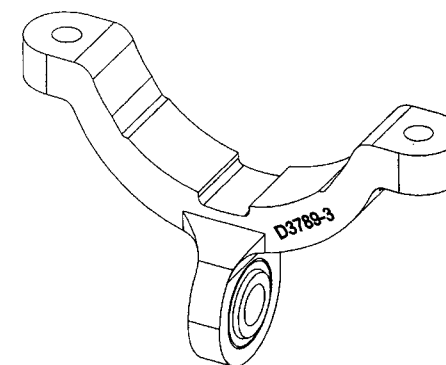
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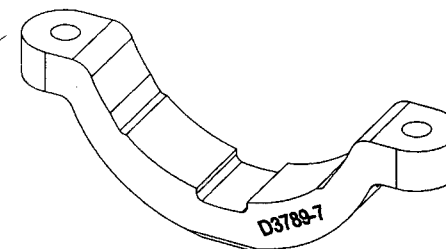
D3789-1 CLAMP



D3789-5 CLAMP



D3789-3 CLAMP



D3789-7 CLAMP



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86188 MLJ
12/06/22

DEO ATTACHED

RELEASED
08/12/22 MLJ

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs
D3789-3, 0.16 lbs
D3789-5, 0.14 lbs
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMETRICAL ABOUT ϕ

A		NEW ISSUE		HS	08.05.21
REV.	DESCRIPTION			BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A
DRAWN	HS				
CHECKED		DRAWING NO. D3789			SHEET 1 OF 5
MFG. APPR.		TITLE			SCALE
APPROVED		CLAMP			NTS
DE APPR.					
DATE	08.05.21				
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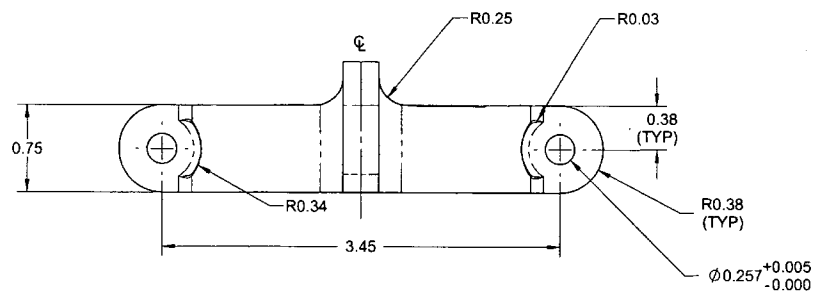
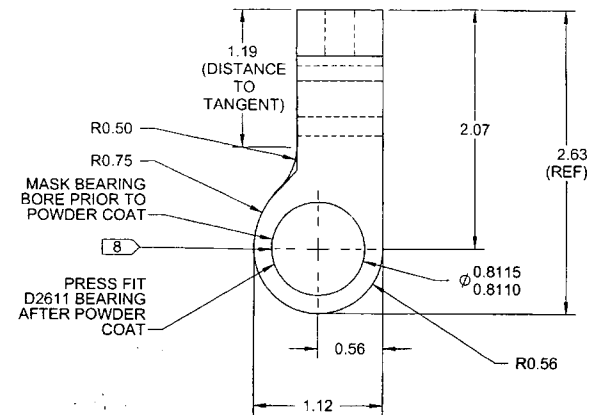
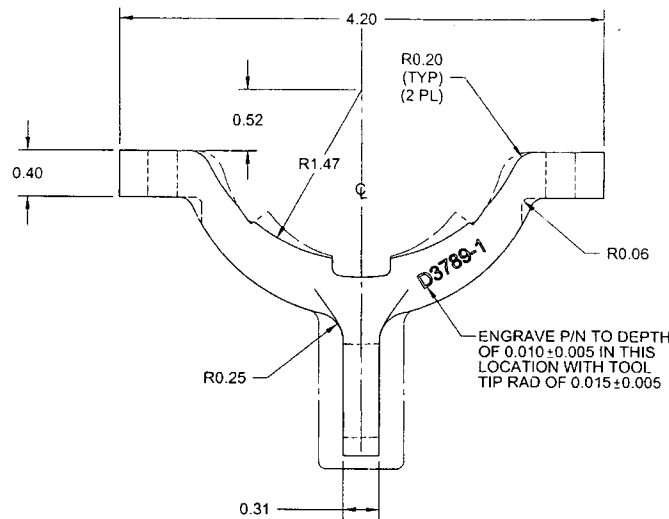
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D3789-1 CLAMP

DEO ATTACHED

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08/12/21

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MFG. APPR.	HS	D3789	SHEET 2 OF 5
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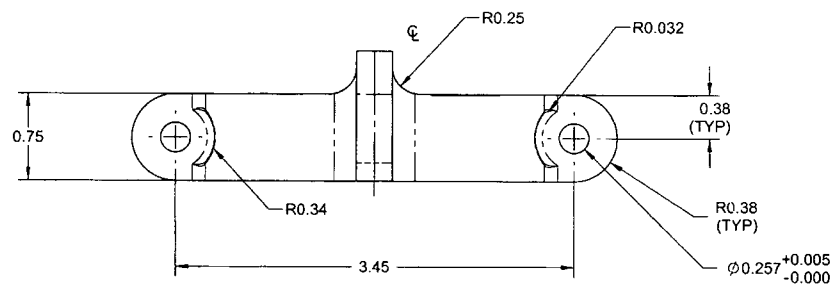
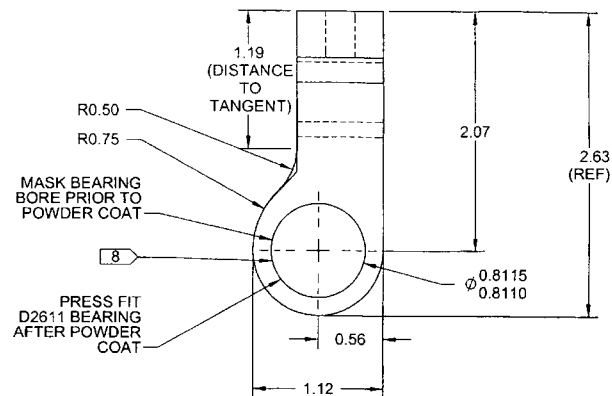
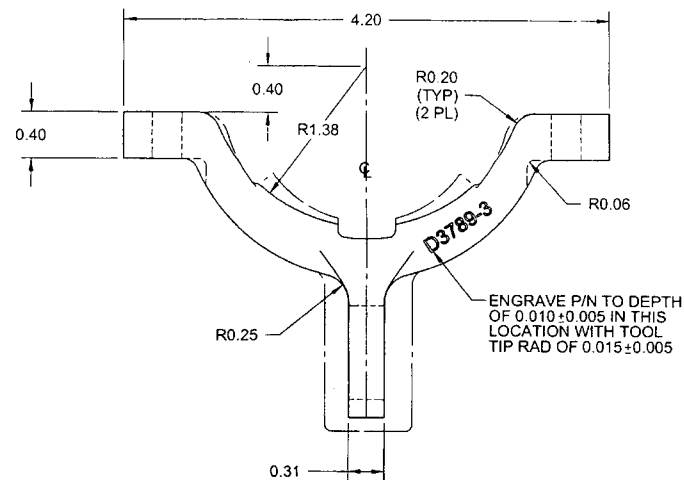
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
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D3789-3 CLAMP

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RELEASE
08/12/21

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MFG. APPR.			D3789	SHEET 3 OF 5
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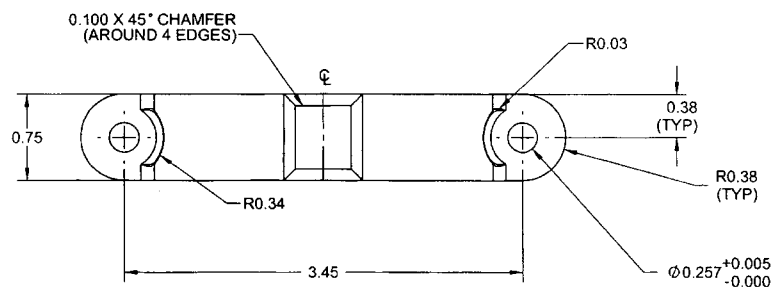
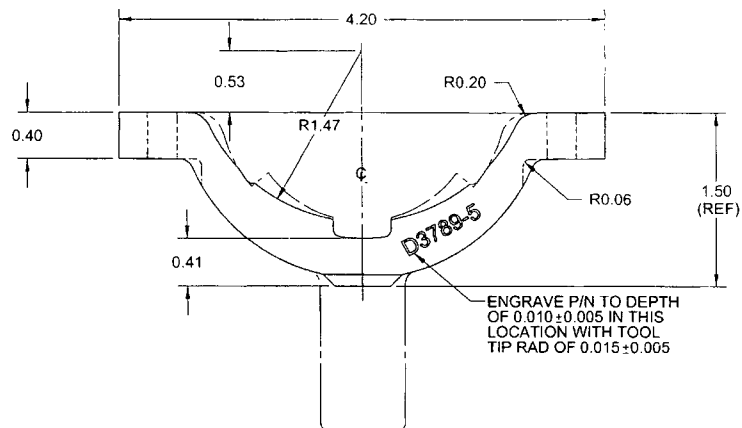
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D3789-5 CLAMP

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08/12/21

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APPROVED			SCALE NTS
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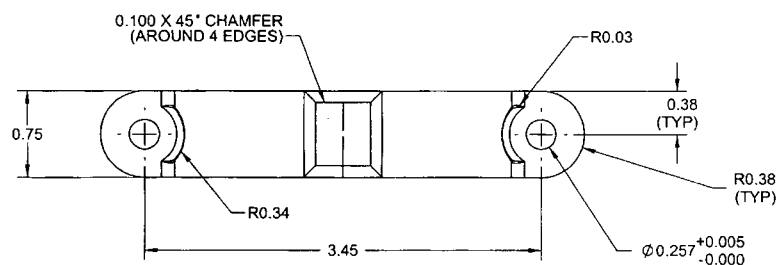
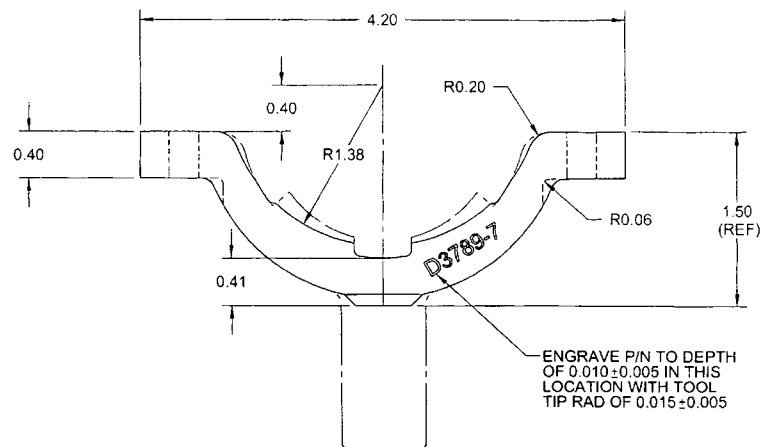
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86128



D3789-7 CLAMP

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MFG. APPR.	<i>[Signature]</i>	D3789	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CLAMP	NTS
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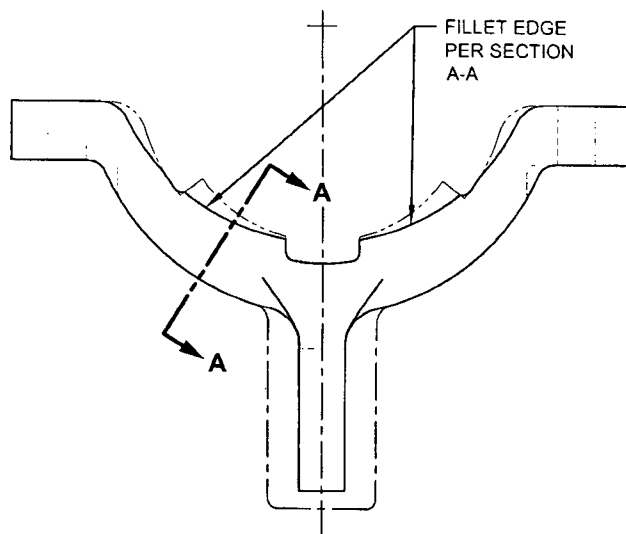
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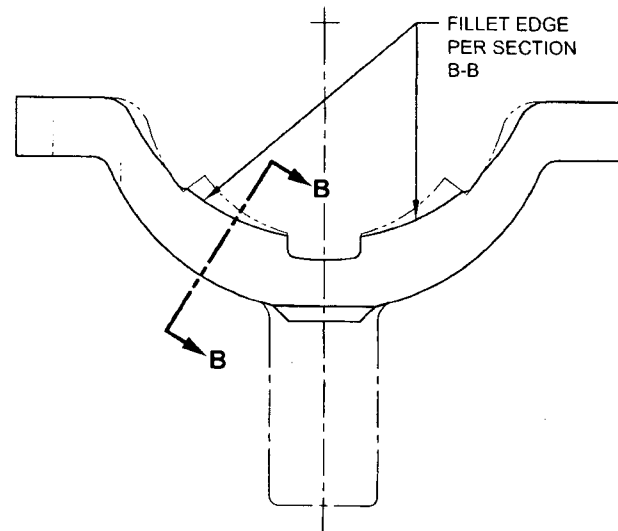
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DRAWN AJS	CHECKED [Signature]	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23		DATE 09/04/23		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



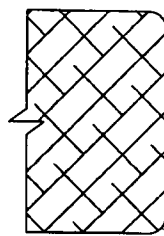
D3789-1 CLAMP

D3789-3 CLAMP



D3789-5 CLAMP

D3789-7 CLAMP



R0.06 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/25/24 [Signature]

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NOTE: Date & initial all entries



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.:

18572

Date:

Jun 29, 2012

Page:

1

Sold to:		Ship to:	
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7		Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	
Order No.:	17295	Sold By:	Dewar, Eric
Shipped By:	your truck	Ship Date:	Jul 06, 2012

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3789-3 Clamp as per dwg. D3789 Rev.A B86188	Each	20	20	
D3789-7 Clamp as per dwg. D 3789 Rev.A B86187	Each	20	20	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	D3789-3	Clamp	17295
20	D3789-7	Clamp	17295

MATERIAL: supplied by DART B81557

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, July 9, 2012